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RBEA62316
Job Sheet 189510



Part No: RBEA62316

Job Qty: 1 pcs

Part Name: Main Rotor Mast Change



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/25/19

Job Tracking No:

Due Date: 3/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 11787 SHIP 20 MARCH

Note: DWG RBEA62316 Rev.2 IPP Rev. A 18.12.20 New issue DP Verify DD

Ship Via:



Container No: S170381



Part: RBEA62316

Job No: 189510

Serial No/Batch: S170381

Revision: C

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Date: 04/08/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	3/20/19		0.00	0.05	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	3/20/19		0.00	0.00	QC 5 - 10		DAS 40 9-89 APR 08 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Packaging 3-1 - Stock - B4B	1 pcs	3/20/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 21 9-89 APR 08 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	1 pcs	3/20/19		0.00	0.00	QC 21 - FG - 21		
Part Op Descriptions: 100 - Pick.									

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RBEA62316-1	Case 1	1 pcs (1 ea)	100-Small Fab - 1	5170163
RBEA62316-47	Case 2	1 pcs (1 ea)	100-Small Fab - 1	5170398

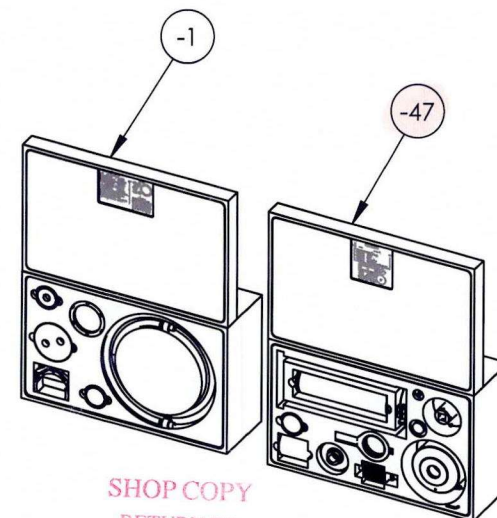
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	RBEA62316-1	1	0	0
	RBEA62316-47	1	0	0

Part Specifications	
Specifications could not be found.	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-11 CORRECTED ITEM 33 P/N & DESCRIPTION FROM RBEL133M-6705-101 SPINDLE TO RBE1X56-122-264 PUSH-OUT DEVICE.	4/29/2013	RJC	RW
2	15-0219	UPDATED TO NEW DRAFTING STANDARDS. CH'D DESCRIPTIONS WAS SPANNER IS SOCKET WRENCH, WAS SERVO SCREW DRIVER IS TORQUE MULTIPLIER & COUNTER HOLDER, WAS SUPPORT IS FIXTURE ASSEMBLY, REMOVED TOOL DASH NUMBERS. -1 & -47 REPLACED TOOL DASH NUMBERS WITH TOOL NUMBERS. -3 CH'D DIM WAS 3X 9.00 IS 4X 9.00. DELETED DIMS 8.985, 9.50. ADDED DIM 19.51. -9 CH'D DIMS WAS 5.00 IS 5.06, WAS 8.00 IS 8.06. -49 CH'D DIMS WAS Ø4.20 IS Ø4.43, WAS 3.25 IS 3.37. DELETED DIMS 1.38, .84, 2X .80, 7.61. ADDED DIMS 5.91, 7.29, 9.41, 6.18, 7.02, 9.97, 16.63, 9.09, 16.70, 4X R.70, 2X R.70. -51 CH'D DIMS WAS 6.00 IS 6.06, WAS 6.00 IS 6.06. -53 CH'D DESCRIPTIONS WAS SUPPORT IS FIXTURE ASSEMBLY, WAS SPANNER IS SOCKET WRENCH, WAS SERVO SCREW DRIVER IS TORQUE MULTIPLIER & COUNTER HOLDER. -55 CH'D DIM WAS 3.55 IS 3.29. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	9/1/2015	DPD	JAG

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	CASE 1			2
	1	B/O	-3		BOTTOM FOAM, TOP SHELF	Y-20 BLACK	2.40 X 17.97 X 29.01 (I.R. SPECIALTY)	3
	1	B/O	-5		BOTTOM FOAM, LOWER SHELF	Y-20, BLACK	6.08 X 17.78 X 28.82 (I.R. SPECIALTY)	4
	1	B/O	-7		TOP SHELF STIFFENER	BLACK COROPLAST	.24 X 17.78 X 28.82 (I.R. SPECIALTY)	5
	1	B/O	-9		TOP FOAM	C200, BLACK FLAT	1.80 X 18.04 X 29.13 (I.R. SPECIALTY)	6
	1		-11		PLACARD	PLASTIC		7
1	1	B/O	-13		CASE		PELICAN #APP-1650-E	2 / 8
	1	B/O	-15		HAND PUMP		(POWER TEAM #P12)	2
	1	B/O	-17		5 TON JACK		(POWER TEAM #C55CBT)	2
	1	B/O	-19		12 TON JACK		(POWER TEAM #RH121)	2
	1	B/O	-31		HOSE ASSY	RUBBER BRAIDED	1/4 I.D. X 6ft POWER TEAM #9754	2
	1				THREADED PULLER		RBEVR-L11-0010-002-1	2
	1				PRESS TOOL		RBEVR-L11-0010-005-B	2
	1				PRESS TOOL		RBEVR-L11-0010-004-B	2
	1				ROD ASSEMBLY		RBEVR-L11-0010-002-D	2
	1				ROD ASSEMBLY		RBEVR-L11-0010-002-B	2
	1				PUSH-OUT DEVICE		RBE1X56-122-294	2
	1				MOUNTING TOOL		RBEL133M-6705-101	2
	1				THRUST PIECE		RBE1X53-174-739-2	2
	1				PRESS TOOL		RBE1X54-176-875	2
	1				GROOVE NUT		RBE1X46-182-024	2
	1				SPACER		RBEVR-L11-0010-003-B	2
	1				PRESS TOOL		RBEVR-L11-0010-002-2	2
X			-47	1	CASE 2			8
1		B/O	-49		BOTTOM FOAM	Y-20, BLACK	8.81 X 17.97 X 29.01 (I.R. SPECIALTY)	9
1		B/O	-51		TOP FOAM	C200, BLACK FLAT	1.80 X 18.04 X 29.13 (I.R. SPECIALTY)	10
1			-53		PLACARD	PLASTIC		11
2		B/O	-55		REINFORCEMENT	BLACK COROPLAST	4mm X 3-1/8 X 3-1/8 (I.R. SPECIALTY)	12
1					THRUST PIECE		RBE1X53-166-817-13	8
1					RELEASE MECHANISM		RBE1X53-174-739-1	8
1					ADAPTER		RBE1X25-166-857	8
1					ADAPTER		RBE1X25-166-856	8
1					PULLER		RBE1X53-166-817	8
1					FIXTURE ASSEMBLY		RBE1X46-175-575	8
1					SOCKET WRENCH		RBE1X36-166-807	8
1					TORQUE MULTIPLIER & COUNTER HOLDER		RBE1X56-136-858	8
ASSY -47	ASSY -1							



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189510 MLC
19-02-25

DART
AEROSPACE

TITLE			EC135 MAST CHANGE KIT		
DWG NO.			RBEA62316		
REV			2		
MATERIAL			DRAWN BY: GILBERT		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			APPROVED <i>D Weil</i>		
.XXX ± .005			HEAT TREAT		
.XX ± .01			FINISH		
.X ± .1			SPEC		
1. BREAK ALL SHARP EDGES .015 x 45°			USED ON MODEL		
OR .015R			EC135		
2. DIMENSIONAL LIMITS APPLY AFTER PLATING					
SCALE		1:24	DATE		4/11/2012
					SHEET 1 OF 12